

# Work Order ID 61093

August 6, 2010 8:39:17 AM



# PRELIMINARY ISSUE

Page 1

Item ID: D4102-1

Accept



Setup Start



Revision ID:

Item Name: SHIM

Stop



Start Date: 07/08/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 09/08/2010 Req'd Qty: 1.00

Customer:



Reference:

*10-08-06*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4102

REV. PRELIM

*PB2 7-11*

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

4.950" long

*88 10/08/09*

*1 / 0*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA945

FOLIO REV: *AA*

DWG REV: *PB2*

*88 10/08/09*

*1 / 0*

DEBURR

# Work Order ID 61093

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Item ID:	D4102-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SHIM					
Start Date:	07/08/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	09/08/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo □□	0.00  0.00		<i>ST 10/08/09</i>		<i>1</i>	<i>0</i>		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>inspect to PD2 only</i> <i>8/10/06/10</i>					
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<i>m</i>	<i>10</i>	<i>08</i>	<i>10</i>

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Item ID:	D4102-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SHIM					
Start Date:	07/08/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	09/08/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			U 10-08-10						
160  Packaging Packaging	Identify as per dwg & Stock Location:  Memo DAVID Shepper	0.00  0.00							
			1-5-10 SD						
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							
			RD 1347 Aug						

POSITIVE RECALL

EFFECTIVE 10-08-10 AUTH U

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

MF  
10-8-10

# Picklist Print

Page 1

August 6, 2010 8:39:16 AM

Work Order ID: 61093



Parent Item: D4102-1



Parent Item Name: SHIM

Start Date: 07/08/2010

Required Date: 09/08/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased		No		100	f	16.2347	0.042	0.044211			



6061-T6 Bar .250 x 4.00

Location

Loc Qty

Loc Code

MAT

16.234734

110680

0.279156

114608

15.955578

0443 SP 10/08/09

DART AEROSPACE LTD		Work Order: 61093
Description: SKIA		Part Number: 24102-1
Inspection Dwg: 24102	Rev: DB2	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.426	$\pm .010$	.428	✓		✓ SF12	
.495	"	.498	✓		"	
.630	"	.630	✓		"	
.675	"	.676	✓		"	
1.413	"	1.415	✓		"	
2.656	"	2.656	✓		"	
3.035	"	3.037	✓		"	
3.510	"	3.512	✓		"	
3.644	"	3.644	✓		"	
4.00	$\pm .030$	4.013	✓		"	
4.75	"	4.75	✓		"	
4.234	$\pm .010$	4.236	✓		"	
3.940	"	3.942	✓		"	
3.770	"	3.771	✓		"	
3.413	"	3.419	✓		"	
2.315	"	2.317	✓		"	
2.290	"	2.292	✓		"	
1.534	"	1.535	✓		"	
1.125	"	1.128	✓		"	
.718	"	.719	✓		"	
.600	"	.602	✓		"	
.213	$\pm .015$	.216	✓		"	
.130	$\pm .040$	.140	✓		"	

Measured by: SS
Date: 10/08/09

Audited by: S
Date: 10/08/10

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

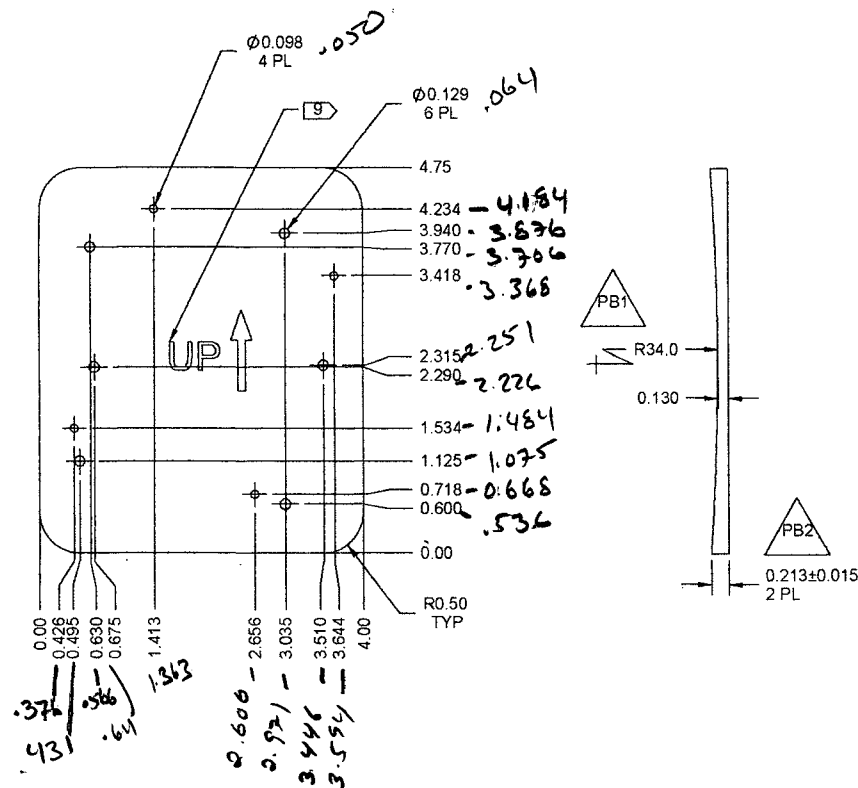
10.04.15

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by: Q	Preliminary Approval:
Date:		Date: 10/22/10	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revE

10.04.15



PRELIMINARY ISSUE

10.08.05

D4102-1 SHIM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
PER DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4102-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.29 lbs
- 8) SURFACE FINISH MINIMUM 250 MICROINCH
- 9) ENGRAVE "UP & ARROW" TO A DEPTH OF MAXIMUM 0.020 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.063

w/o 61093

PB2	REMOVED R45.0 & SECTION VIEW A-A (ZN SHEET 1); 0.213 WAS 0.176 (ZN B4-1, D4-2); REMOVED R45.0 & SECTION VIEW B-B (ZN SHEET 2)	RF	10.08.05
PB1	0.210 WAS 0.239 (ZN D2-1 & D3-2); ADD 0.130 & R34.0 (ZN C4-1 & C4-2); R34.0 WAS 35.3 & 0.167 WAS 0.170 (ZN C3-3); ADD R24.1 & 0.167 (ZN D6-3); 0.239 WAS 0.241 (ZN D3-3)	RF	10.07.30
A	NEW ISSUE	RF	10.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D4102	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

## Kim Johnston

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** Thursday, August 12, 2010 12:24 PM  
**To:** 'Kim Johnston'  
**Subject:** RE: three more prelim work orders

Kim,

Yes ... These parts will also be scrapped after testing.

David

-----Original Message-----

**From:** Kim Johnston [mailto:kjohnston@dartaero.com]  
**Sent:** Thursday, August 12, 2010 5:48 AM  
**To:** David Shepherd  
**Subject:** three more prelim work orders

Hi David,

I have three more prelim work orders, D4102-1 B61093, D4102-2 B61095 and D4102-3 B61096. Have they also been sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after.

I'll attach your email to the work orders and file them. Thanks,

Kim Johnston  
Dart Aerospace Ltd.  
Engineering Clerk  
Document Control  
1270 Aberdeen Street  
Hawkesbury, Ontario, K6A 1K7  
Email: kjohnston@dartaero.com  
Tel: 613-632-5200  
Fax: 613-632-9311

No virus found in this incoming message.

Checked by AVG - [www.avg.com](http://www.avg.com)

Version: 8.5.441 / Virus Database: 271.1.1/3066 - Release Date: 08/12/10 06:34:00